

Work Order ID 86948

86948

Page 1

July-09-12 2:57:39 PM

Item ID: D2174-041 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Web, 205
 Start Date: 7/06/12 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 12/07/10 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start *NR1*
 Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2174	Rev E

100	Small Fab	0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per Dwg D2174-0412- Identify as D2174-041								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
120									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>11:45</u> FINISH TIME: <u>12:15</u> OVEN TEMPERATURE: _____								

M121841

3200 F

12-15

6x 12/07/27

(16)

6x 12/07/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86948

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Page 2

July-09-12 2:57:39 PM

Item ID: D2174-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Web, 205
 Start Date: 7/06/12 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 7/06/12 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00							
Quality Control									
140		0.00							
140	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Install nuts & bolts loosely as per Dwg D2274								
150	QC5- Inspect part completeness to step on W/O	0.00							
150									
QC	Memo	0.00							
Quality Control									

6x 6 11/07/31

6x 12/07/31

SMB
12-7-31

DAS
16
2-83

12/07/31

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 86948***86948***

Page 3

July-09-12 2:57:39 PM

Item ID: D2174-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Web, 205

Start Date: 7/06/12 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/06/12 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Identify as per dwg & Stock Location: <u>240</u>	0.00				<u>60</u>		<u>12/8/25</u>	
160									
Packaging	Memo	0.00							
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170									
QC	Memo	0.00							
Quality Control									

12/8/7 JD
MCS 12/08/03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-09-12 2:57:38 PM

Page 1

Work Order ID: 86948
Parent Item: D2174-041
Parent Item Name: Web, 205

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP: D04.06.10Reformat; Changed Step 2KJ/JLM
IPP Rev:E As per Rev E 06-11-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN526C832R14 Screw		Purchased	No			140	Each	396.0000	4	24		7/12/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST348		396							
				104916		396							
AN960JD8 Washer	NAS1149DN832J	Purchased	No			140	Each	0.0000	4	24		7/12/12	
D2174-1 Web		Manufactured	No			100	Each	4.0000	1	6		7/12/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		4							
				79469		4							
D2175-1 Angle LH		Manufactured	No			100	Each	0.0000	1	6		7/12/12	
D2175-2 Angle RH		Manufactured	No			100	Each	0.0000	1	6		7/12/12	
MS20470AD4-6 Rivet, Universal Head		Purchased	No			140	Each	2,129.0000	19	114		7/12/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST319		2129							
				117395		16							
				118927		279							
				119109		12							
				120142		81							
				121524		1741							

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

July-09-12 2:57:39 PM

Page 2

Work Order ID: 86948

Parent Item: D2174-041

Parent Item Name: Web, 205

Start Date: 7/06/12

Required Date: 7/06/12

Start Qty: 6.00

Required Qty: 6.00

MS21042L08

Purchased

No

100

Each

833.0000

4

24

Nut

Location

Loc Qty

Loc Code

ST300

33

121524

33

ST317

800

122141

800

24

EB 12/07/13

July-09-12 2:57:39 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

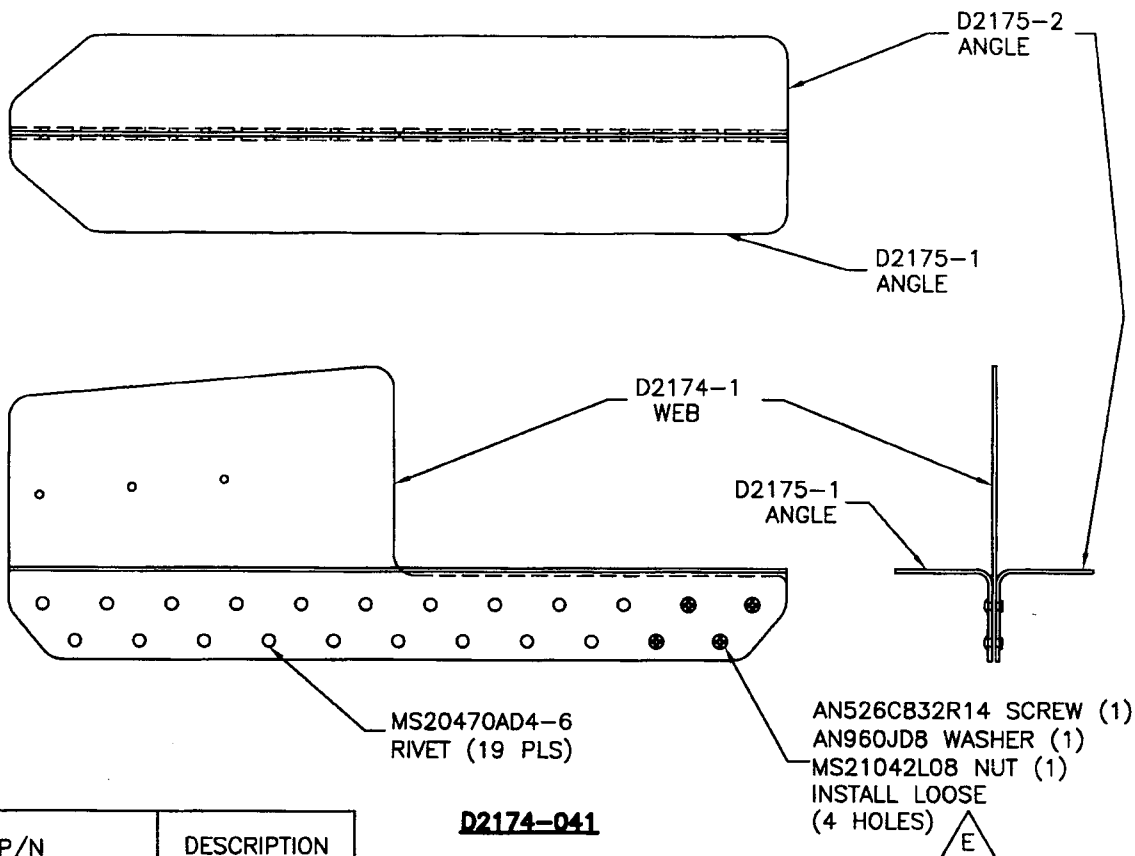
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART

DESIGN	RF	DRAWN BY	DATE	CHECKED	APPROVED	DRAWING NO.	REV. E
		CE	06.09.25	PH	CH	D2174	SHEET 1 OF 2
						WEB ASSEMBLY	SCALE 1:3
A		95.10.25	NEW ISSUE				
B		96.01.18	RE-DRAWN				
C		00.09.11	UPDATE FINISH SPEC.				
D		04.06.03	RE-DESIGN				
E		06.09.25	INC 4 HOLES TO Ø0.172; CHG HARDWARE				



D2174-041

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86948 MLJ
12/07/10

RELEASED
06.10.13

QTY -041	P/N	DESCRIPTION
X	D2174-041	WEB ASSEMBLY
1	D2174-1	WEB
1	D2175-2	ANGLE
1	D2175-1	ANGLE
4	AN526C832R14	SCREW
4	AN960JD8	WASHER
4	MS21042L08	NUT
19	MS20470AD4-6	RIVET

NOTES:

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) IDENTIFY WITH P/N D2174-041 USING FIND POINT PERMANENT INK MARKER.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

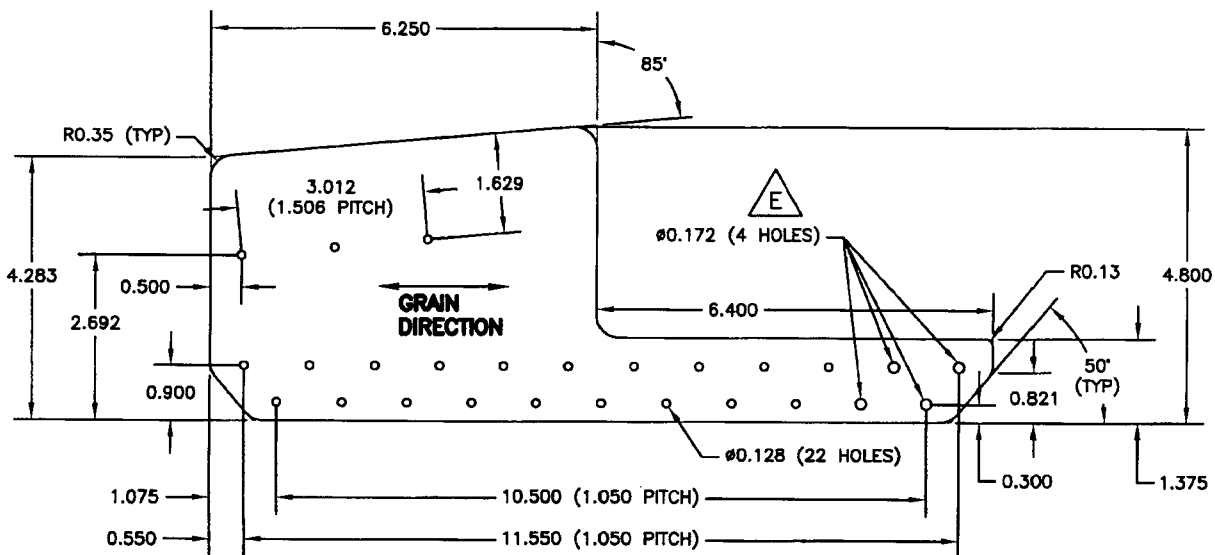
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY CE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED [Signature]	DRAWING NO. D2174	REV. E SHEET 2 OF 2
DATE 06.09.25	TITLE WEB		SCALE 1:3



D2174-1

NOTES:

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-200/4) 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSION ARE IN INCHES

ALL INFORMATION CONTAINED
HEREIN IS UNCLASSIFIED
DATE 06-16-03 BY 111

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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